

Date: Tuesday, 24/02/2009 8:08:38 AM
 User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WHEEL SHAFT
Job Number	: 46043		
Estimate Number	: 10449		
P.O. Number	:	Part Number	: D33341
This Issue	: 24/02/2009 S.O. No. :	Drawing Number	: D3334 REV. C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11 Type : MACHINED PARTS	Drawing Revision	: C
Previous Run	: 45084	Material	:
Written By	: <u>JLM 09.02.24</u>	Due Date	: 03/03/2009 Qty: 12 Um: Each
Checked & Approved By	:		
Comment	: Est: B 05.03.02 Revised material; Added Powder Coat K J/JLM Est Rev: C Now on Doosan Lathe 08-03-06 JLM Verified By: EC Est Rev: D Now Rev C 08-05-14 JLM Verified By: DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M4140HR3500	4140 RD bar 3.500
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Comment: Qty.: 0.6563 f(s)/Unit Total: 7.8756 f(s)

4140 HEAT TREATED BAR

Material: AISI 4140 or ASTM A304-02/A-434-BC/A193-03-Grade-B7/A29-03/A322-91 or UNS# G41400

(M4140H-R3.500)

Batch: 111027

6" x lap. cant used it.

JLM 09/03/19

(12)

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

1- Cut blanks: Ø3.500" Bar to 7.750" long

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(12)

3.0	DOOSAN LATHE	DOOSAN LATHE
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Comment: DOOSAN LATHE

1- Turn and Mill as per Folio FA492 and Dwg D3334

2- Deburr

Test Thread with Test Nut for every part

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(12)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

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(12)

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

JLM 09/03/20

(12)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WHEEL SHAFT

Job Number: 46043

Part Number: D33341

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

Mask thread and bearing surface

START TIME:

8:25

OVEN TEMPERATURE:

320°

FINISH TIME:

8:55

imp/ Fx

X/2

09/03/23

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



hl

Comment: INSPECT POWDER COAT

09 - 03 - 23

X/2

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

OML

09/03/23 (12)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



09/03/24

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 09-03-23

DART AEROSPACE LTD		Work Order: 46043
Description: Wheel Shaft		Part Number: D3334-1
Inspection Dwg: D3334 Rev: C		Page 1 of 1

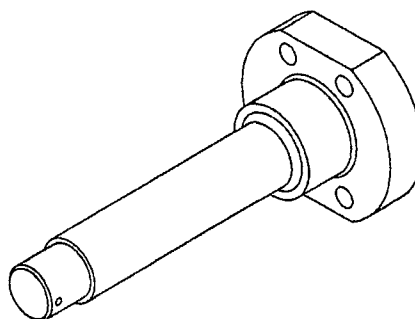
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.94	+/-0.030	.944	✓			
0.200	+/-0.010	.204	✓			
Ø0.129	+0.005/-0.000	Ø.129	✓			
4.740	+0.000/-0.030	4.731	✓			
1.04	+/-0.030	1.050	✓			
Ø1.750	+/-0.010	Ø1.750	✓			
0.750	+/-0.010	.757	✓			
1.180	+0.000/-0.002	1.1797	✓			
2.250	+/-0.005	2.250	✓			
1.125	+/-0.010	1.125	✓			
3.060	+/-0.010	3.060	✓			
Ø0.386	+0.006/-0.001	Ø.386	✓			
1.300	+/-0.005	1.300	✓			
Ø3.470	+/-0.010	Ø3.473	✓			

Measured by: <i>mf</i>	Audited by: <i>JTP</i>	Prototype Approval:	N/A
Date: 09/03/19	Date: 09/03/20	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue	KJ/JLM	
B	08.05.06	Tolerance for dimension Ø0.386 revised	KJ/DD	
C	08.05.14	Dimensions updated per Dwg Rev C	KJ/JLM	



D3334-1 WHEEL SHAFT

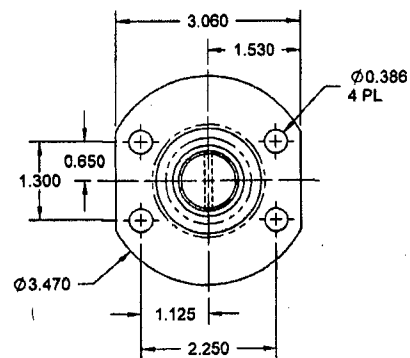
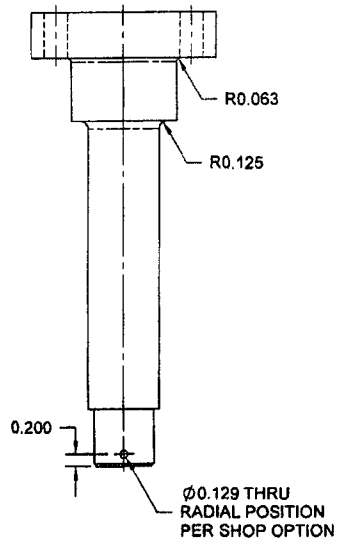
w/o 46043

RELEASED
06-05-13

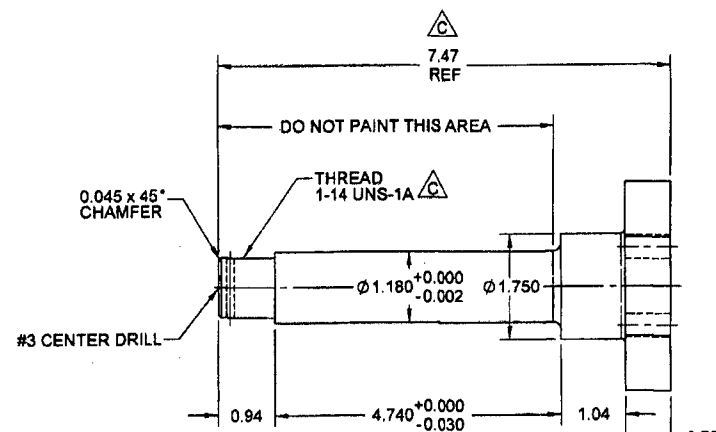
NOTES:

- 1) MATERIAL: AISI 4140 OR ASTM A304-02/ A-434-BC/ A193-03-GRADE-B7/ A29-03/ A322-91
OR: UNS#-G41400
(REF. DART SPEC. M4140H-R3.500)
- 2) FINISH: POWDER COAT COLOUR FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3334-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 4.03 lbs

C	INCORPORATED B1 (0.5470 WAS 3.500) REFORMAT TO CURRENT STANDARDS, TOP VIEW ADDED, ZN C3-2 7.47 REF WAS 7.468, ZN B3-2 THREAD CALL OUT WAS 1.14 UNF. ZN C5-2 COTTER PIN HOLE LOCATION (RADIAL) CHANGED TO SHOP OPTION.	AJS	08.05.12
B	REDESIGN TO FIT NEW WHEEL ASSY.	MB	05.02.16
A	NEW ISSUE	MB	04.12.16
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS	DRAWING NO.	REV. C
CHECKED	AJS	D3334	SHEET 1 OF 2
MFG. APPR.	[Signature]	TITLE	SCALE
APPROVED	[Signature]	WHEEL SHAFT	NTS
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DATE	08.05.12		



D3334-1 WHEEL SHAFT



RELEASED
08-DS-13710

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3334	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WHEEL SHAFT	NTS
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